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**PATENT**

Our Case No. 00172

**IN THE UNITED STATES PATENT AND TRADEMARK OFFICE**

**Applicant:** Savenok, Peter

**Serial No.:** To Be Assigned

**Filed:** To Be Assigned

**For:** Method For Manufacture Of A  
Balustrade Of Synthetic Material  
And Apparatus Thereof



**Art Unit:** To Be Assigned

**Examiner:** To Be Assigned

**Honorable Commissioner of Patents and Trademarks**  
**Washington, D.C. 20231**

**AMENDMENT BEFORE ACTION**

Dear Honorable Commissioner:

Applicant respectfully requests that the following amendment be entered before the filing fee is calculated.

**IN THE TITLE**

Please cancel the present title, and substitute instead:

--Method Of Manufacturing A Balustrade of Synthetic Material---

10054661-000500

IN THE SPECIFICATION

On page 1, line 5, after "This is a" insert divisional of Application No. 09/286,796,  
filed April 6, 1999, which is a new.

On page 1, delete lines 8-12, and insert instead The present invention relates generally  
to a new and improved method of manufacturing a synthetic stone rail, and more specifically, to  
a method of manufacturing a synthetic stone rail article in the form of a balustrade product  
containing holes for receiving a connecting structure. ~

On page 2, line 9, after "method" please delete "and apparatus".

On page 2, line 11, after "novel" please delete "features and devices" and insert instead -  
steps--.

On page 2, line 15, after "improved" delete "method and apparatus for forming a  
balustrade product. It is another object to provide a balustrade having a connection structure that  
allows for a quick and easy connection of a balustrade with a post or support structure." and  
insert instead a method of manufacturing a balustrade product comprising the steps of,

providing a mold having a first half and a second half, the first and second mold halves defining  
an inner cylindrical surface, stabilizing a plurality of hollow pipes within the mold parallel to the  
longitudinal axis of the mold and in close proximity to the inner cylindrical surface, pouring a  
predetermined amount of casting material into the second half of the mold, securing the first and  
second mold halves together, rotating said mold until the casting material has set to form the  
balustrade product, and removing the balustrade product from the mold. ~

On page 3, line 1, after "method" delete "and apparatus".

On page 3, line 8, before "alignment" delete "properly" and insert instead -proper--.

On page 4, line 21, after "method" delete "and apparatus".

On page 8, line 4, after "view" insert -of--.

On page 9, line 6, after "Application No." delete "08/910,636, filed August 13, 1997" and insert instead -09/286,796, filed April 6, 1999--.

On page 10, line 16, after "conventional" delete "designed" and insert instead -design--.

On page 13, line 4, before "mold is closed" insert -the--.

On page 13, line 19, before "an extruded aluminum" delete "a".

On page 14, line 2, before "being cut" insert -balustrade product 10--.

On page 15, line 10, after "spring acts to" delete "forces" and insert instead -force--.

#### IN THE ABSTRACT

Please cancel the present abstract, and substitute instead:

By What is disclosed is a method of manufacturing a balustrade product comprising the steps of, providing a mold having a first half and a second half, the first and second mold halves defining an inner cylindrical surface, stabilizing a plurality of hollow pipes within the mold parallel to the longitudinal axis of the mold and in close proximity to the inner cylindrical surface, pouring a predetermined amount of casting material into the second half of the mold, securing the first and second mold halves together, rotating said mold until the casting material has set to form the balustrade product, and removing the balustrade product from the mold.

IN THE CLAIMS CANCEL

Please cancel claims 1-15 without prejudice.

IN THE CLAIMS AMEND

In Claim 16, line 2, after "form" insert ~~of--~~.

In Claim 16, line 3, after "defining" delete "a" and insert instead ~~an--~~.

In Claim 16, line 23, after "rotating" delete ~~,"~~.

In Claim 17, line 1, after "made from" delete ~~"a"~~.

In Claim 19, line 1, before "mold" insert ~~centrifugal--~~.

In Claim 19, line 1, after "mold" delete ~~"being made of a"~~ and insert instead ~~is~~  
comprised of--.

IN THE CLAIMS ADD

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25  
Rule 1.126 21. A method of manufacturing a balustrade product comprising the steps of:

providing a mold having an inner cylindrical surface defining a cavity,

extending the plurality of hollow pipes within the mold to be integrated into the  
balustrade product, the hollow pipes spanning substantially the entire length of the cavity,

35 securing the hollow pipes within the cavity of the mold in a preset position that is  
parallel to its longitudinal axis and in close proximity to the inner cylindrical surface,

pouring a predetermined amount of casting material into the mold,

rotating said mold until the casting material has set to form the balustrade product,

and

removing the balustrade product from the mold.

Rule 1.126 <sup>26</sup> 26. The method of claim <sup>25</sup> 21, wherein the step of securing the hollow pipes within the cavity further comprising the steps of providing a plurality of supports within the mold having a plurality of openings, and extending the plurality of hollow pipes through the plurality of openings, wherein the diameter of each opening is slightly larger than the diameter of the hollow pipe passing therethrough.

Rule 1.126 <sup>27</sup> 27. The method of claim <sup>26</sup> 26 further comprising the step of engaging a plurality of tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby assisting in holding the hollow pipes in a suspended preset position within the mold.

Rule 1.126 <sup>28</sup> 28. The method of claim <sup>27</sup> 27 further comprising the step of engaging a plurality of tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby embedding the tabs in the balustrade product after the casting material has set.

Rule 1.126 <sup>29</sup> 29. The method of claim <sup>25</sup> 21 further comprising the step of grinding the outer surface of the balustrade product after removing the balustrade product from the mold to provide a smooth outer surface.

Rule 1.126 <sup>30</sup> 30. The method of claim <sup>25</sup> 21, wherein the casting material comprises a slurry of synthetic stone material.

Rule 1.126 <sup>31</sup> 27.

A method of manufacturing a balustrade product comprising the steps of:

providing a mold having a first half and a second half, the first and second mold halves defining an inner cylindrical surface,

stabilizing a plurality of hollow pipes within the mold parallel to the longitudinal axis of the mold and in close proximity to the inner cylindrical surface,

pouring a predetermined amount of casting material into the second half of the mold,

securing the first and second mold halves together,

rotating said mold until the casting material has set to form the balustrade product,

and

removing the balustrade product from the mold.

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The method of claim <sup>31</sup> 27, wherein the step of stabilizing comprises the steps of extending the plurality of hollow pipes through a plurality of openings in a plurality of supports, and placing same in the second mold half.

Rule 1.126 <sup>33</sup> 29.

The method of claim <sup>32</sup> 28 further comprising the step of spacing the plurality of supports longitudinally along the length of the plurality of hollow pipes at predetermined intervals.

Rule 1.126 <sup>34</sup> 30.

The method of claim <sup>33</sup> 29 further comprising the step of engaging a plurality of

tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby assisting in holding the hollow pipes in a suspended preset position within the mold.

*B- (concl'd) Rule 1.126* 31. <sup>35</sup> The method of claim <sup>34</sup> ~~30~~ further comprising the step of engaging a plurality of tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby embedding the tabs in the balustrade product after the casting material has set.

### CONCLUSION

Applicant now believes that application is in condition for allowance and such action is respectfully requested.

Respectfully submitted,  
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